

Work Order ID 158141

Monday, March 13, 2017 8:40:56 AM

158141

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Item ID: D5155-047 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Co-Pilot Collective Head Assembly (205)
Start Date: 3/17/2017 Start Qty: 3.00 ***3*** Cust Item ID:
Required Date: 3/30/2017 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan:  Date: MAR 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5155	B

110 Weld per dwg A/R Aluminum rod Batch: M/2937 0.00***110***

Large Fab

Memo

0.05

Large Fab

WELD D5054-1 to D5155-7 AS PER DWG

3 R 17-3-14

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

3 17-03-15DAS
9
9-89

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

3 17-03-15DAS
9
9-89

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG: <u>35698</u> Black Anodize as per Dwg D5155 C OF C REQUIRED	0.00 36.00				<u>3</u>			DAS 13 9-89 MAR 23 2017
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo C OF C REQUIRED	0.00 0.00							3x Sp17-03-29
160 *160* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				<u>3</u>			DAS 38 9-89 MAR 29 2017

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N900040100

Setup Start *NS1*

Stop ***NS2***

3

Cust Item ID:

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Run Start *NR1*

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200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.05							
Quality Control									

DAS
21
9-89 MAR 30 2017

DAS
21
9-89 MAR 30 2017

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☐	Out of Sequence																																																																																																																																						
☐	Off-set																																																																																																																																						
☐	Mislabeled																																																																																																																																						
☐	Fit/Function																																																																																																																																						
☐	Misaligned/off center																																																																																																																																						
☐	Positioned Wrong																																																																																																																																						
☐	Outside Dimensions																																																																																																																																						
☐	Over/Under tolerance																																																																																																																																						
☐	Part Incorrect																																																																																																																																						
☐	Part Lost/Missing																																																																																																																																						
☐	Part Moved																																																																																																																																						
☐	Drawing																																																																																																																																						
☐	Finish																																																																																																																																						
☐	Misread																																																																																																																																						
☐	Turning Sequence																																																																																																																																						
				OTHER : _____																																																																																																																																			

Picklist Print

Monday, March 13, 2017 8:40:56 AM

Work Order ID: 158141

158141

Parent Item: D5155-047

D5155-047

Parent Item Name: Co-Pilot Collective Head Assembly (205)

Start Date: 3/17/2017

Required Date: 3/30/2017

Start Qty: 3.00

Required Qty: 3.00

D5156-9 Manufactured No

170 Each 16.0000 1 3

D5156-9

Back Plate

**

DAS
6
9-89

MAR 29 2017

Location Loc Qty Loc Code

375 1

135053 1

ST375 15

143501 15

90296A108 Purchased No

170 Each 157.0000 11 33

90296A108

Heli-Coil Insert

**

DAS
30
9-89

MAR 29 2017

Location Loc Qty Loc Code

GA 157

m132757 32

m136548 100

m136747 25

MS16562-223 Purchased No

170 Each 41.0000 2 6

MS16562-223

Spring Pin

**

DAS
6
9-89

MAR 29 2017

Location Loc Qty Loc Code

ST316 41

m134574 16

m135536 25

MS24693-24B Purchased No

170 Each 127.0000 7 21

MS24693-24B

Screw

**

DAS
6
9-89

MAR 29 2017

Location Loc Qty Loc Code

GA 100

m134676 100

ST288 27

m134676 27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
QC				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Monday, March 13, 2017 8:40:56 AM

Work Order ID: 158141

158141

Parent Item: D5155-047

D5155-047

Parent Item Name: Co-Pilot Collective Head Assembly (205)

Start Date: 3/17/2017

Required Date: 3/30/2017

Start Qty: 3.00

Required Qty: 3.00

MS27641-3

Purchased

No

170

Each

7.0000

1

3

MS27641-3

BEARING

Location

Loc Qty

Loc Code

ST275

7

M128936

2

M133363

5

DAS
6
9-89

MAR 29 2017

2
1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

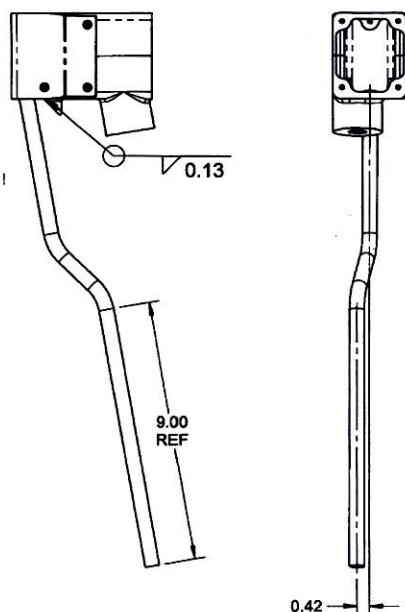
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐		No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐		Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐		Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐		Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐		Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐		Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐		Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐		Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐		Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐		Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐		Manufacturing Process	☐							
Misidentified	☐		Past Due	☐							
				OTHER :							

ITEM	QTY	P/N	DESCRIPTION
1	X	D5155-047	CO-PILOT COLLECTIVE HEAD ASSEMBLY
2	1	D5054-1	CONDUIT
3	2	D5073-1	SNAP RING
4	1	D5155-7	CO-PILOT COLLECTIVE HEAD (205)
5	1	D5155-9	CO-PILOT COLLECTIVE HEAD (205)
6	1	D5156-9	BACK PLATE
7	11	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	2	MS16562-223	SLOTTED SPRING PIN
9	7	MS24693-24B	SCREW, CSK 100°
10	1	MS27641-3	BEARING

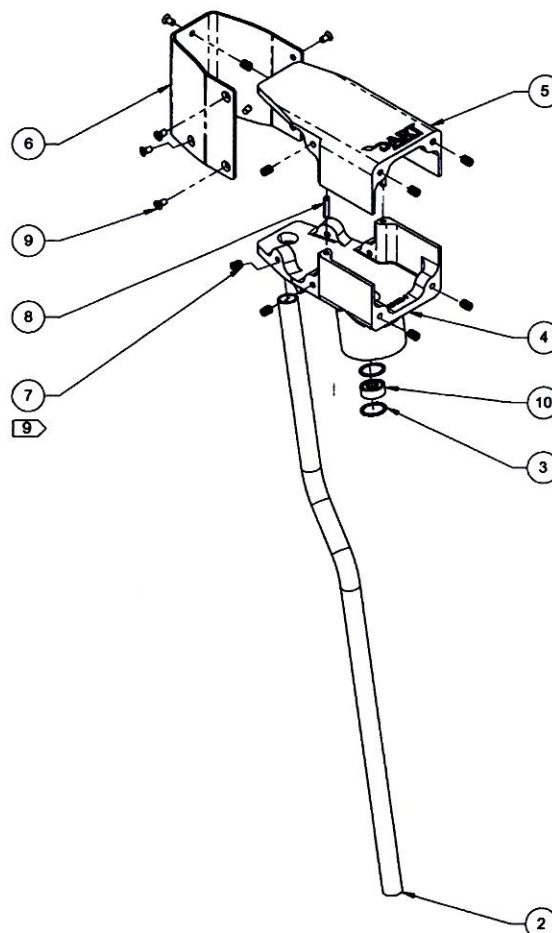


D5155-047 WELDING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.14 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

**D5155-047 CO-PILOT COLLECTIVE HEAD ASSY
FOR 205 WITH 204-001-290-5 STICK AND THROTTLE ASSEMBLY INSTALLED**

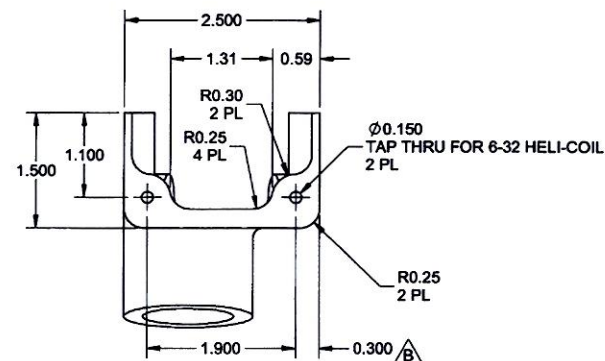
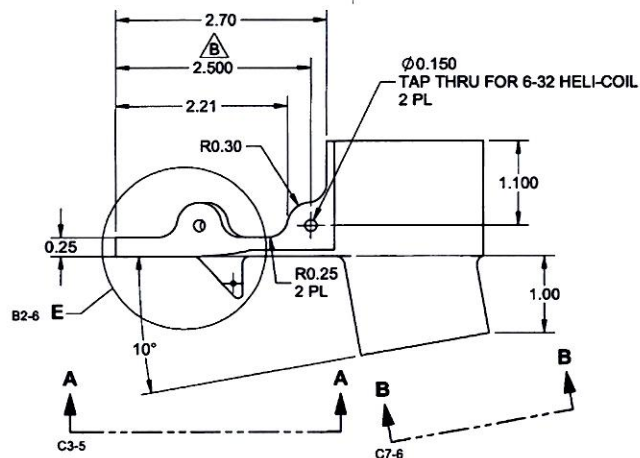
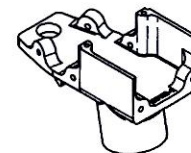
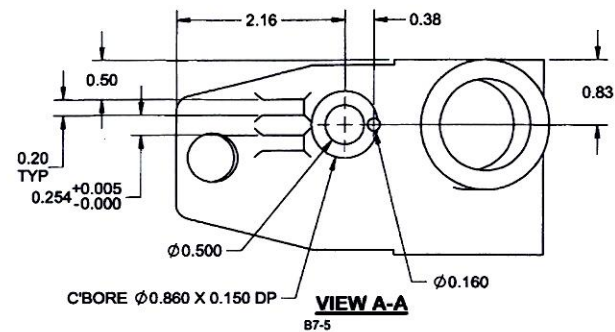


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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158141
MAR 13 2017

RELEASED

A-E 2015 JUL 02

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5155	SHEET 4 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

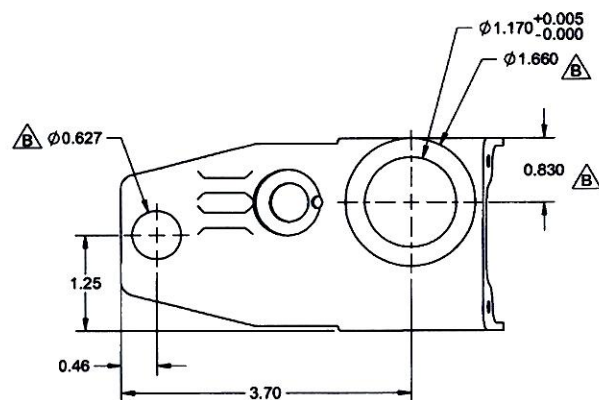


A.P. 2015 JUL 02

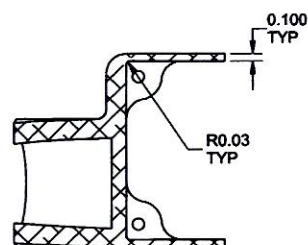
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
7) WEIGHT: 0.47 lbs
8) UNDIMENSIONED FEATURES ARE DEFINED BY D5155-1.SLDPRT

D5155-1 CO-PILOT COLLECTIVE HEAD (205)

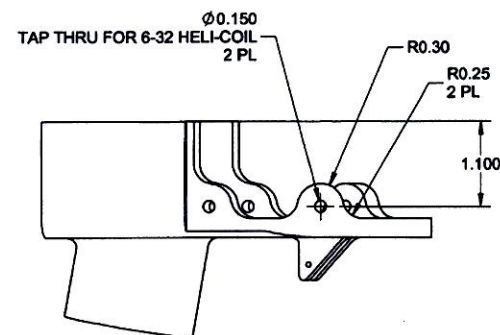
DESIGN	VS	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	VS			
CHECKED	RF		DRAWING NO. D5155	REV. B
MFG. APPR.	JFS			SHEET 5 OF 14
APPROVED	HS		TITLE	SCALE
DE APPR.	DS		CO-PILOT COLLECTIVE HEAD	NTS
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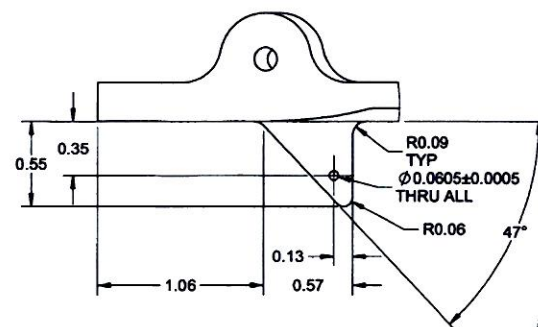
VIEW B-B
B5-5



SECTION D-D
D6-5



VIEW C-C
D7-5



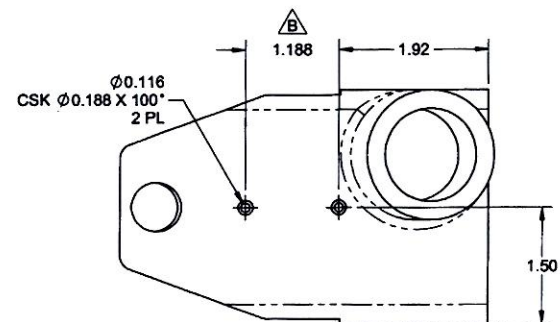
DETAIL E
B7-5

RELEASED
A.E. 2015 JUL 02

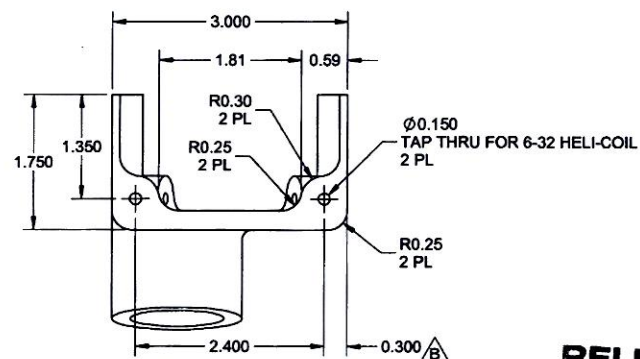
- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

D5155-1 CO-PILOT COLLECTIVE HEAD (205)
DETAIL VIEWS

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 6 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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B7-7



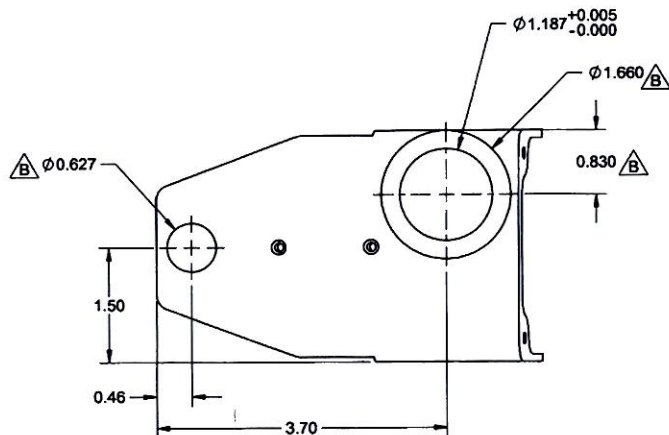
A.P. 2015 JUL 02

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
7) WEIGHT: 0.51 lbs
8) UNDIMENSIONED FEATURES DEFINED BY D5155-3.SLDPRT

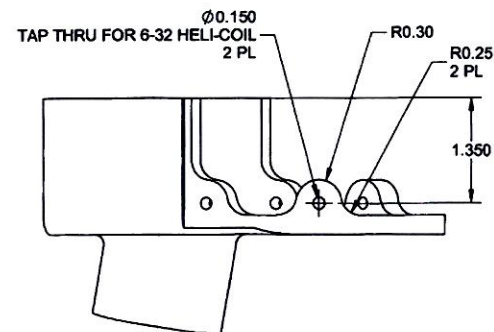
D5155-3 CO-PILOT COLLECTIVE HEAD (212)

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA DRAWING NO. D5155 TITLE CO-PILOT COLLECTIVE HEAD COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS A PROPERTY OF DART AEROSPACE LTD. A SUPPLIER'S RESPONSIBILITY IS TO NOT TO BE USED FOR ANY PURPOSE OR CONSIDERED TO BE ANY OTHER PERSON'S WITHOUT WRITTEN PERMISSION BY DART AEROSPACE LTD.	REV. B
	DRAWN	VS		SHEET 7 OF 14
	CHECKED	RF		SCALE
	MFG. APPR.	JFS		NTS
	APPROVED	HS		
	DE APPR.	DS		
	DATE	15.05.21		

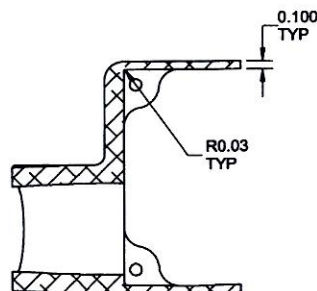
8 7 6 5 4 3 2 1



VIEW G-G
B6-7



VIEW H-H
D7-7



SECTION I-I
D6-7

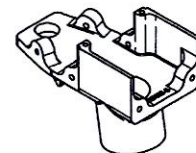
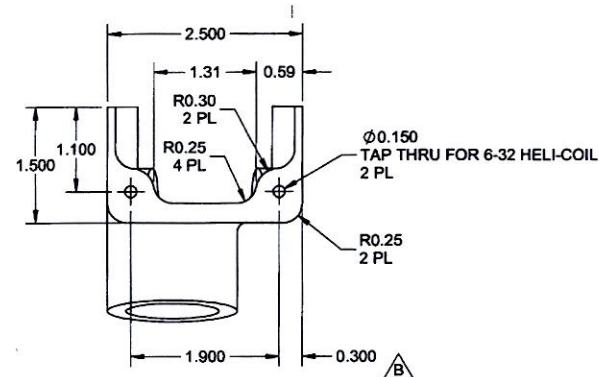
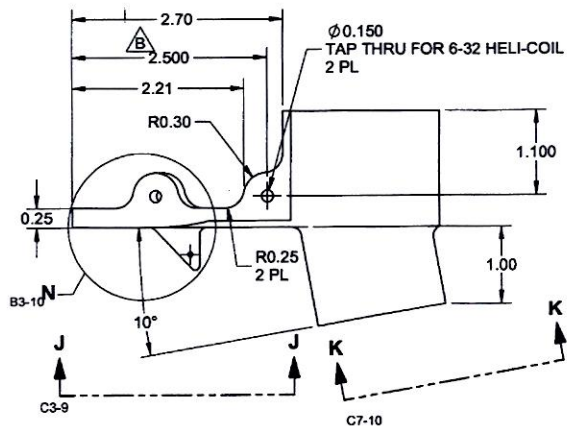
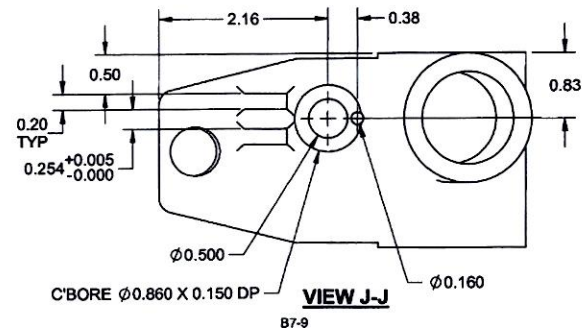
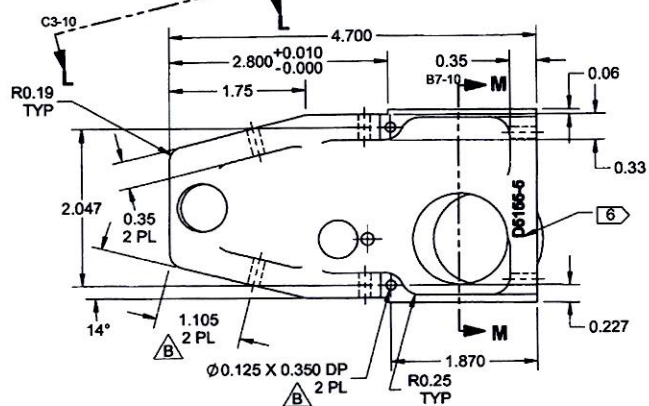
RELEASED
A.R. 2015 JUL 02

- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

D5155-3 CO-PILOT COLLECTIVE HEAD (212)
DETAIL VIEWS

APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 8 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE		15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.45 lbs
- 8) UNDIMENSIONED FEATURES DEFINED BY D5155-5.SLDPRT

D5155-5 CO-PILOT COLLECTIVE HEAD (EAGLE SINGLE)

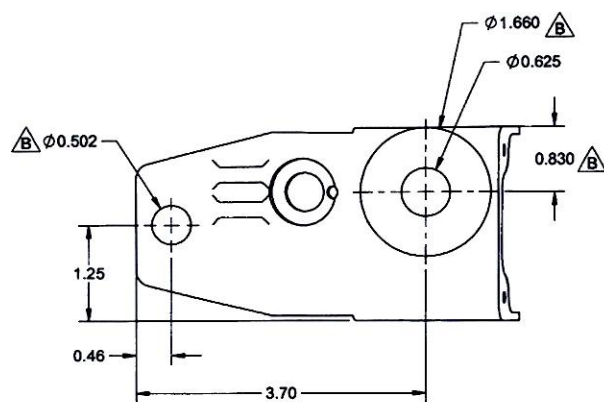
RELEASED

15 JUL 02

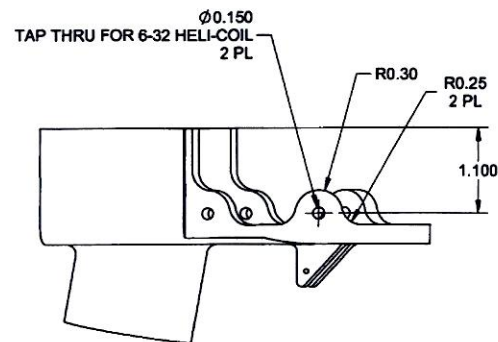
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	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 9 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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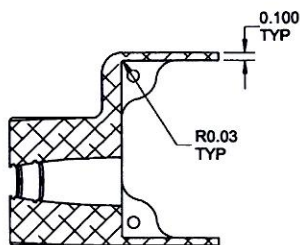
REV. APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5155 TITLE CO-PILOT COLLECTIVE HEAD	REV. B
	DRAWN	VS		SHEET 10 OF 14
	CHECKED	RF		SCALE
	MFG. APPR.	JFS		NTS
	APPROVED	HS		
	DE APPR.	DS		
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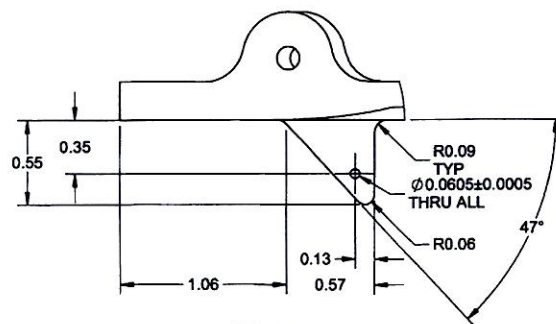
VIEW P-P
B5-11



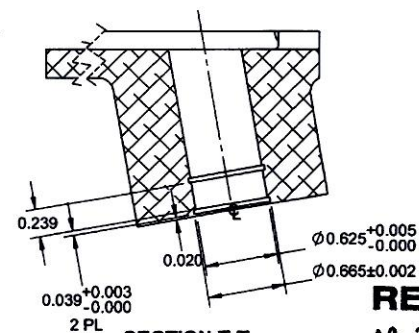
VIEW Q-Q
D7-11



SECTION R-R
C6-11



DETAIL S
B6-11



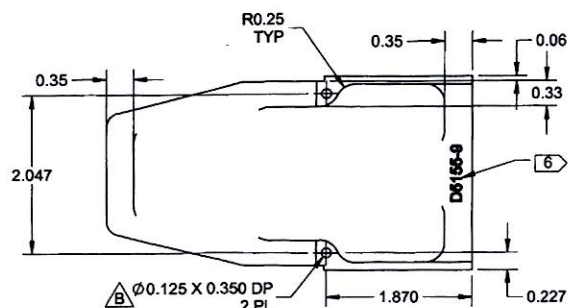
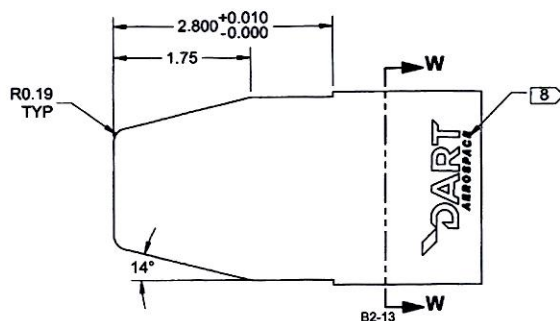
SECTION T-T
B2-11

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A.R. 2015 JUL 02

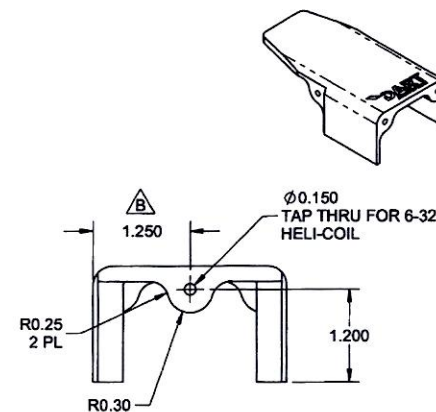
- NOTES:**
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

D5155-7 CO-PILOT COLLECTIVE HEAD (205)
DETAIL VIEWS

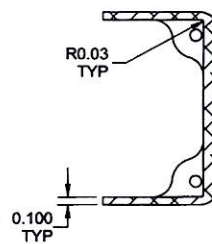
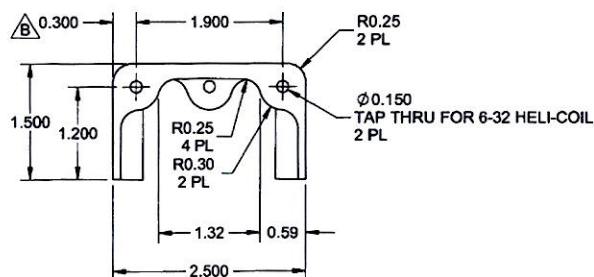
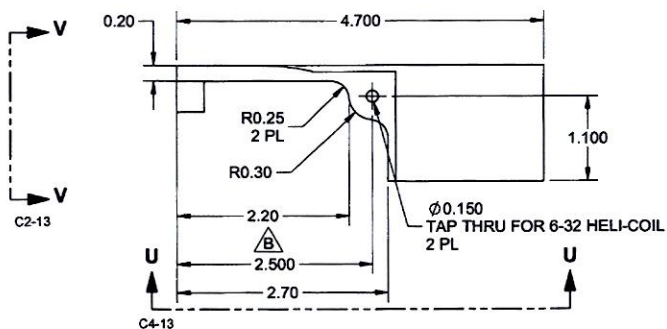
APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 12 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE		15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



VIEW U-U
B7-13



VIEW V-V
B8-13



SECTION W-W
D6-13

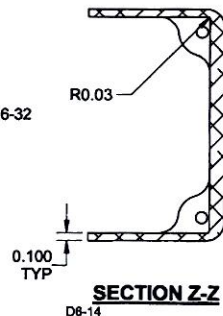
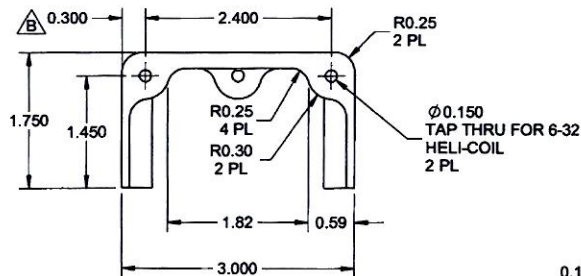
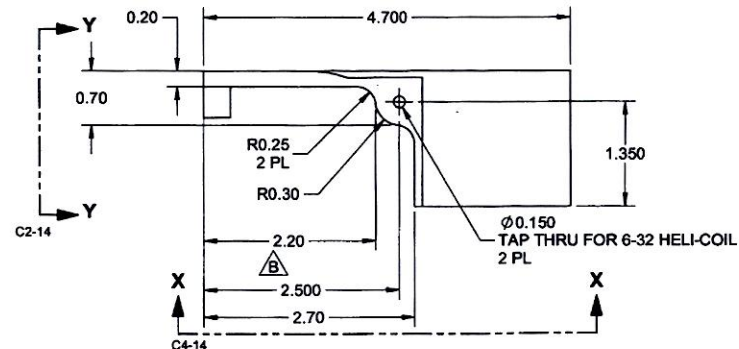
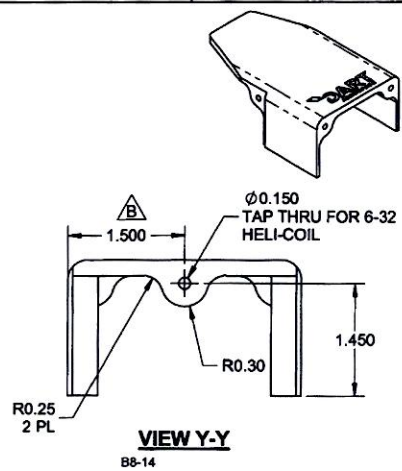
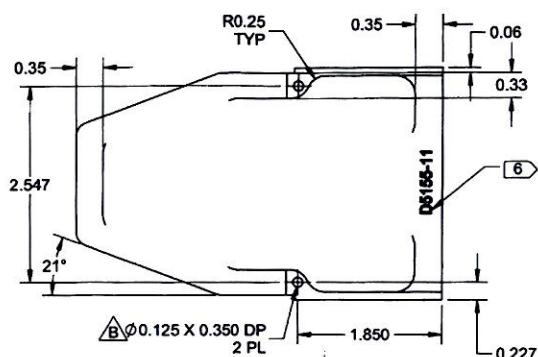
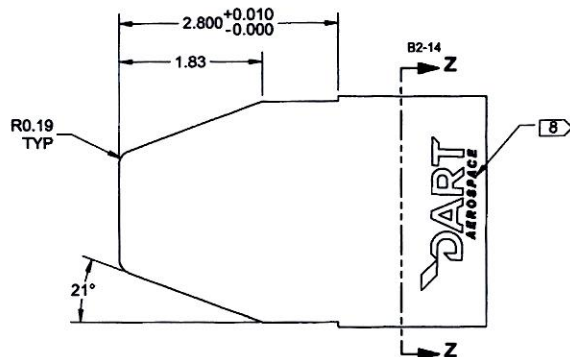
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.31 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
- 9) UNDIMENSIONED FEATURES DEFINED BY D5155-9.SLDPRT

D5155-9 CO-PILOT COLLECTIVE HEAD (205)

RELEASED
4.8. 2015 JUL 02

APPROVED	DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 13 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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RELEASED
A.R. 2015 JUL 02

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II
OR IIB CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 IN THIS AREA TO MAX DEPTH
OF 0.010 WITH A MIN. TOOL RAD OF R0.010
 - 7) WEIGHT: 0.36 lbs
 - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003-0.005 DP
 - 8) UNDIMENSIONED FEATURES DEFINED BY D5155-11.SLDPRT

D5155-11 CO-PILOT COLLECTIVE HEAD (212)

APPROVED	DESIGN	VS	DART AEROSPACE LTD	
	DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	RF	DRAWING NO.	REV. B
	MFG. APPR.	JFS	D5155	SHEET 14 OF 14
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE		15.05.21	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO35698

Purchase Order Date 3/23/2017

PO Print Date 3/29/2017

Page Number 1 of 6

Order From :

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAR 29 2017

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	158141	DAS 38 9-89 D5155-047 CO-PILOT REV. B	3/29/2017		3.00	\$8.33	\$24.99
			Yes 3/29/2017				
	PART ARE RUSH PLEASE ADVISE IF POSSIBLE DELIVERY ON THUSDAY 28 BLACK ANODIZE AS PER MIL-A-8625F TYPE 1 OR IB/IC/II/IIB CLASS 2						
						Line Total:	\$24.99
2	154964	646.3810 BRACKET REV. N/C	3/29/2017		9.00	\$6.55	\$58.95
			Yes 3/29/2017				
	PART ARE RUSH PLEASE ADVISE IF POSSIBLE DELIVERY ON THUSDAY 28 FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N						
	154964		4/6/2017		12.00	\$6.55	\$78.60
			4/6/2017				

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

3/29/2017



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913105

Date: 28-Mar-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
3 DAS 38 9-89 ea	Part: D5155-047 Co-Pilot Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20850	Rev: B PO: PO35698 Line: 1	SP/7-03-29
4 ea	Part: D4726-1 Handle Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20864	Rev: A PO: PO35698 Line: 12	
12 ea	Part: D2348 Wearplate Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20865	Rev: C PO: PO35698 Line: 13	
10 ea	Part: D4703-043 Lock pin Black Anodize per MIL-A-8625F, Type II, Class 2 Job: 20866	Rev: A PO: PO35698 Line: 14	
9 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) Job: 20852	Rev: N/C PO: PO35698 Line: 2	
DATE: 28/03/2017			
CERTIFIED SIGNATURE:			
RECEIVER SIGNATURE: _____			



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913105

Date: 28-Mar-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via				
<table border="1"><thead><tr><th>Quantity</th><th>Description</th></tr></thead><tbody><tr><td></td><td> Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS. MADE IN CANADA. SP17 ea 29 </td></tr></tbody></table>		Quantity	Description		Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS. MADE IN CANADA. SP17 ea 29
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